

Work Order ID 109935

December-06-13 8:23:41 AM

\*109935\*

Page 1

Item ID: D2282-041 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: T Assembly  
 Start Date: 12/06/13 Start Qty: 50.00 \*50\* Cust Item ID:  
 Required Date: 12/20/13 Req'd Qty: 50.00 \*50\* Customer:  
 Reference:

Approvals: Process Plan: MLS Date: 13-12-06 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2282	Rev E								
100		0.00							
*100*	Large Fab								
Large Fab	Memo	0.00							
Large Fab	I-Weld as per D2282-041 'T' Handle Assembly Grind chamfers and ensure full penetration as per dwg D2282 *****brush weld right after welding, to take color off ***** A/RER316L SS Filling Rod <u>M125054</u>								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
*110*									
QC	Memo	0.00							
Quality Control									
120		0.00							
*120*	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Tumble								

35 13-12-10 MAL

(35) 13-12-10 DAS  
9  
9-89

35 7/13 13-12-11

# Work Order ID 109935

December-06-13 8:23:42 AM

**\*109935\***

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Item ID: D2282-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: T Assembly  
 Start Date: 12/06/13 Start Qty: 50.00 **\*50\*** Cust Item ID:  
 Required Date: 12/20/13 Req'd Qty: 50.00 **\*50\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 DAS 27 9-89 13/12/16				35 Cen			
140 <b>*140*</b> Packaging Packaging	Identify as per dwg & Stock Location: <u>G-A</u>  Memo	0.00 0.00				35			13/12/16
150 <b>*150*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							13/12/18 CZ 13/12/18

DAS  
36  
9-89

# Picklist Print

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Page 1

Work Order ID: 109935

\*109935\*

Parent Item: D2282-041

\*D2282-041\*

Parent Item Name: T Assembly

Start Date: 12/06/13

Required Date: 12/20/13

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev:A Removed from 9 Digit 05-12-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2282-3		Manufactured	No			100	Each	28.0000	1	50			
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\*D2282-3\*

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Tube

B104605 x 18

Location

Loc Qty

Loc Code

WA001

28

107670

17

74969

11

35

13-12-10 MAL

D2282-5		Manufactured	No			100	Each	46.0000	1	50			
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\*D2282-5\*

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Tube

Location

Loc Qty

Loc Code

WA001

11

74962

11

WA002

35

92093

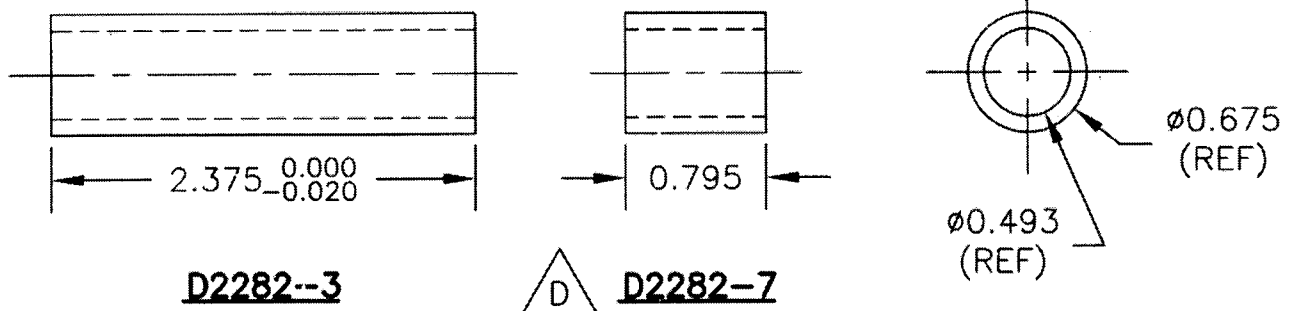
35

35

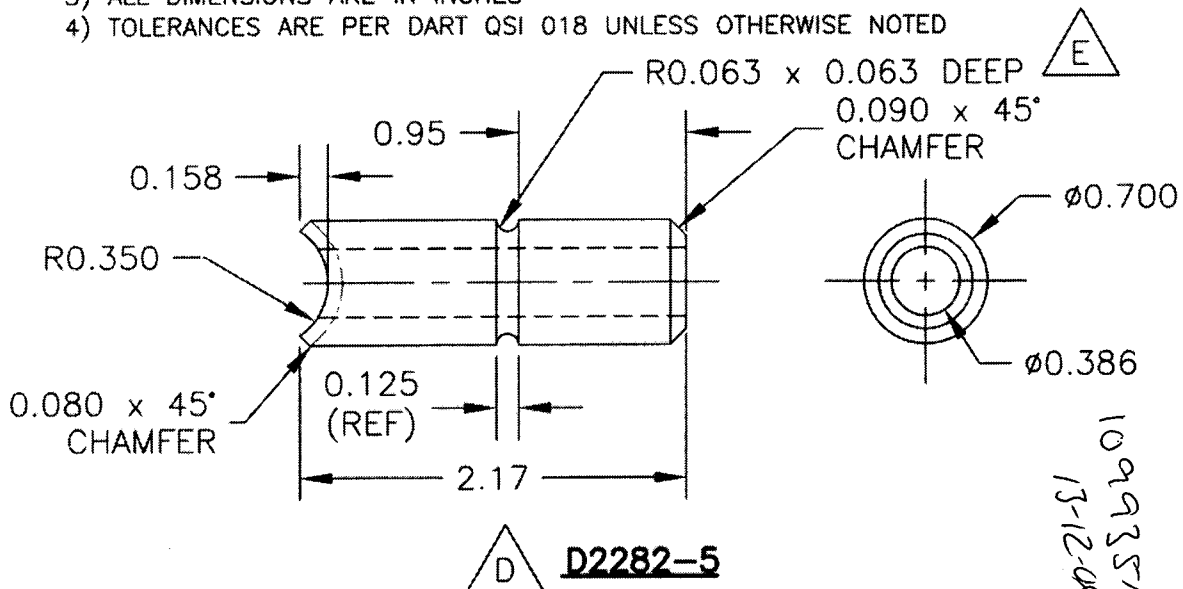
13-12-10 MAL

**DART**RELEASED  
05/09/16

DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

**D2282-3/-7 TUBE:**

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2282-5 STEM:**

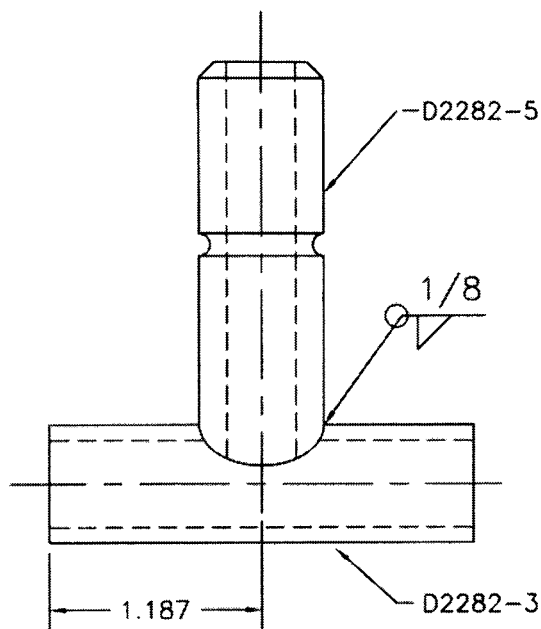
- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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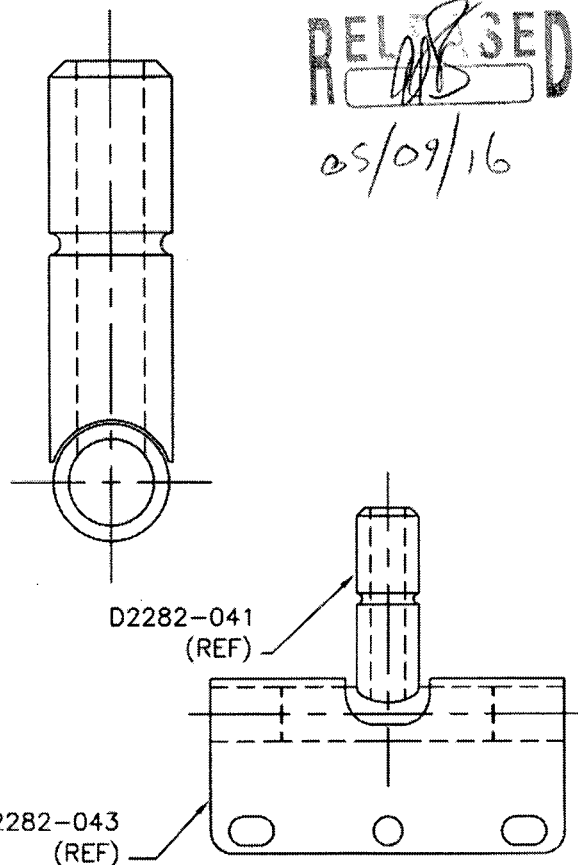
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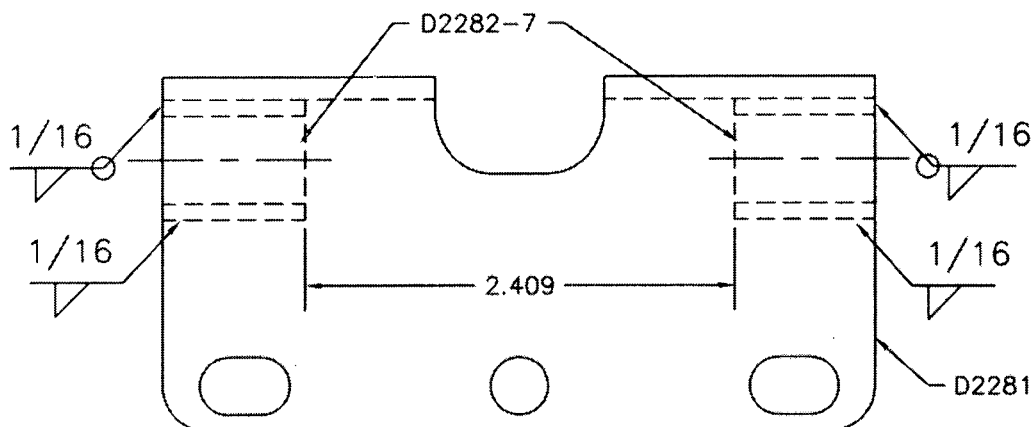
DESIGN BW	DRAWN BY FJ	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED [Signature]	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1



**D2282-041 'T' ASSEMBLY**  
WELD ASSEMBLY PER DART QSI 004



**GENERAL ASSEMBLY**  
SCALE 1:2



**D2282-043 SADDLE ASSEMBLY**  
WELD ASSEMBLY PER DART QSI 004

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